

Date: Wednesday, 1/4/2006 2:34:54 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 205 STEP (STANDARD LOW GEAR)
<b>Job Number</b> : 25386	
<b>Estimate Number</b> : 11666	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D205633017
<b>This Issue</b> : 1/4/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 1/20/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>SEE ABOVE USER &amp; DATE</u>	
<b>Comment</b> : Est Rev:A 04.05.10 New Issue KJ/JLM	

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-633-017CHG001

DA 06/02/13

2.0	25386A	STEP WELDMENT
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**Comment:** Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D2563	Weldment Assembly	B.25386A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2021101	Eyebolt
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2021-101	Eyebolt	B.23483 ✓

P

5.0	D2022101	Spacer
-----	----------	--------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	B.23396 ✓

P

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP (STANDARD LOW GEAR)

Job Number: 25386

Part Number: D205633017

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer B24271 ✓

NO

7.0

D2562007

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-007 Strut B21613 ✓

NO

8.0

D2565401

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-401 Strut 6x B21614 / 2x B25390 ✓

NO

9.0

D2565403

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-403 Strut 6x B21615 / 2x B25391 U

NO

10.0

D2565405

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-405 Strut 6x B21616 / 2x B25388 ✓

NO

11.0

D2565407

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-407 Strut 6x B21617 / 2x B25392 ✓

NO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP (STANDARD LOW GEAR)

Job Number: 25386

Part Number: D205633017

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2565409

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-409

Strut

6 x B 21618 / 2 x B 25393 ✓

No

13.0

D2565411

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-411

Strut

6 x B 21619 / 2 x B 25394 ✓

No

14.0

AN45A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-5A

Bolt

m100089 ✓

P

15.0

AN46A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-6A

Bolt

m18279 x14 / 2 x m19278 ✓

P

16.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A

Bolt

m17697 ✓

P

492

17.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A

Bolt

m15072 ✓

P

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 1/4/2006 2:34:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP (STANDARD LOW GEAR)

Job Number: 25386

Part Number: D205633017

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN56A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-6A

Bolt 1X m13441/m18576 x7

P

19.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A

Bolt m17566

P

20.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416

Washer m19085

P

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer m18100

P

22.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

m17997

P

993

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/02/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 1/4/2006 2:34:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP (STANDARD LOW GEAR)

Job Number: 25386

Part Number: D205633017

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) m19073 ✓

C206102/14 (8)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12/6/22 (8)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-017

Location: B

PPP Rev: B

12/6/22 (8)

26.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

12/06/22/23 (8)

Job Completion



u 06.02.23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:35:03 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STEP WELDMENT	
<b>Job Number</b> :	25386A			
<b>Estimate Number</b> :	10176			
<b>P.O. Number</b> :		<b>Part Number</b> :	D2563	
<b>This Issue</b> :	1/4/2006	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2563 REV C	
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	24478A	<b>Drawing Revision</b> :	C	
		<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	1/20/2006	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :				
<b>Comment</b> :	Est Rev:G 02.07.31 Re-format Location RF			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2244116	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 320457

*SE. 06.01.5*

= 8

2.0	D267334	End Plate
-----	---------	-----------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch

323231

*SE. 06.01.6*

= 8

3.0	D2561	Lug Plate
-----	-------	-----------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch

325088

*SE. 06.01.6*

8

4.0	D2564	Mounting Angle
-----	-------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch

323485 = 8324496 = 8

*SE. 06.01.6*

8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:35:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25386A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

*h.e. 06-01-5 = 8-*

2-Deburr ends

*h.e. 06-01-6 = 8*

3-Inspect for foreign object per QSI 024

*h.e. 06-01-6 = 8*

4-Weld as per Dwg D2563 using DT 8343

*h.e. 06-01-5 = 8*

5-Grind

*h.e. 06-01-9 = 8*

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*PD 06-01-12*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

*7a*



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FF 06-01-13*

*(P10)*

*8*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*PL 06/02/19*

*8*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

*0. 06-02-20*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ML 06 02 20*

*8*

11.0

DC

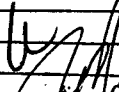
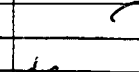
DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*PD 06/02/23*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-02-2	7b	debur after end clean for welding		lf	06-02-2	8		
<del>06-02-2</del>	<del>7c</del>	<del>inspect for potential objects</del>		<del>lf</del>	<del>06-02-2</del>	<del>8</del>		
<del>06-02-2</del>	<del>7d</del>	<del>grind weld end cap as per dwg</del>		<del>lf</del>	<del>06-02-2</del>	<del>8</del>		
<del>06-02-2</del>	<del>7E</del>	<del>grind end</del>		<del>lf</del>	<del>06-02-2</del>	<del>8</del>		
<del>06-02-02</del>	<del>7F</del>	<del>QCS19 Inspect work - weld</del>		<del>lf</del>	<del>06-02-2</del>	<del>8</del>		
06-02-02	7G	Teeth-up end caps with Alodine (As per Q31005 4.1)		lf	06-02-06	8		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

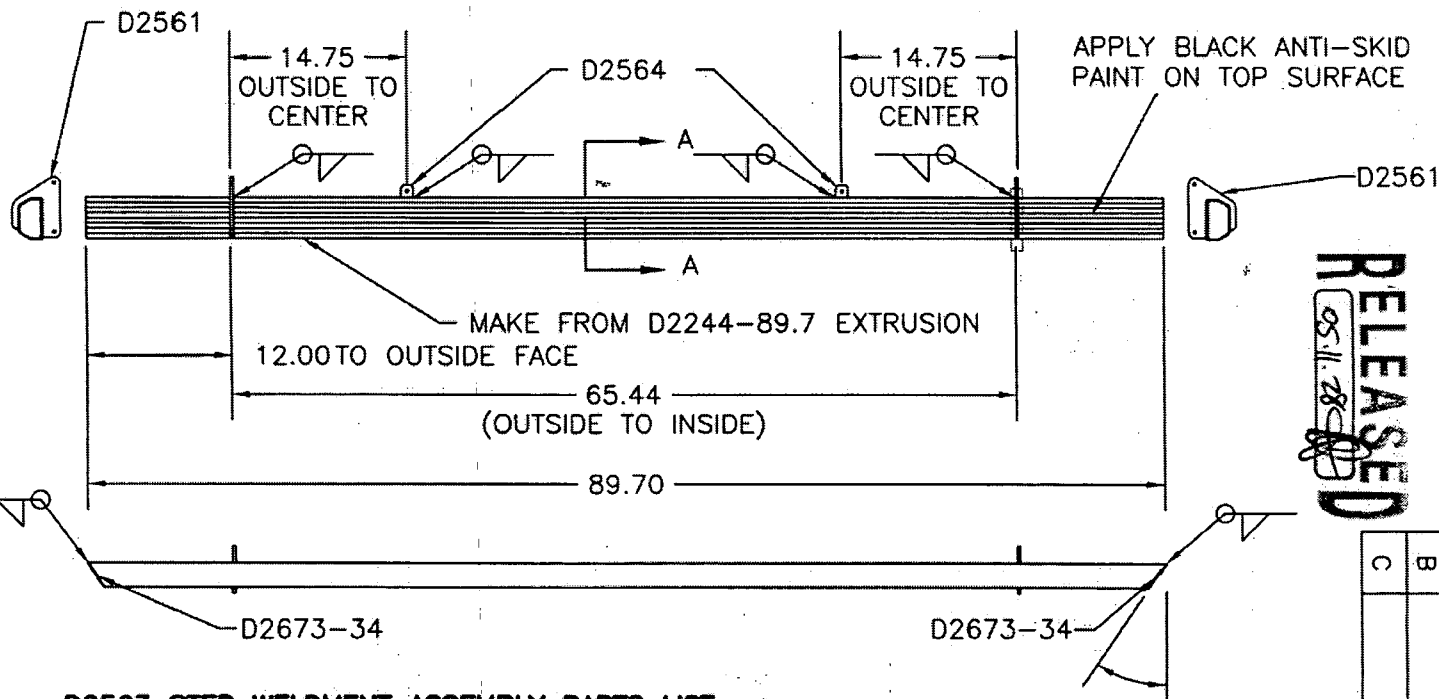
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
05.11.28

DESIGN	BW	DRAWN BY	44	DART AEROSPACE LTD	REV. C
CHECKED		APPROVED		D2563	SHEET 1 OF 1
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY	SCALE	1:15
A	96.04.26	NEW ISSUE			
B	97.05.14	END CAPS CHANGED (WAS D2248)			
C	05.11.14	UPDATE NOTES			



#### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

\*cut per drawing

#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25386A